

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013170**Date Inspected:** 17-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In Process Inspections**Bay 9**

This inspector witnessed grinding of tack welds in preparation for Magnetic Particle inspection, MT, before welding on mock up panel MU1-001.

Bay 8

This inspector witnessed repair welding on traveler rail 10TR5-002 in accordance with B-CWR1340. The welder was identified as 054460, and the WPS was identified as 345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Zhao Cheng Jian.

Repair welding of traveler rail 11TR10-001 in accordance with B-CWR 1340. The welder was identified as 054459, and the WPS was identified as 345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Zhao Cheng Jian.

Repair welding of traveler rail 11TR10-002 in accordance with B-CWR 1340. The welder was identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

054460, and the WPS was identified as 345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Zhao Cheng Jian.

Heat straightening of traveler rail 10TR10-001 in accordance with HSR1(B)-8163.

Bay 7

This inspector witnessed weld repair of traveler rail 22TR2-003 per B- WR- 11866. The welder was identified as 048625. The welding procedure was identified as WPS-345-FCAW-2G(2F)-Repair-1. ZPMC QC was identified as Mr. Xiayong Zheng.

This inspector witnessed carbon arc gouging of the following traveler rails in accordance with B- CWR- 1100 in preparation for weld repair: 10TR3-026, 10TR1-005, 10TR1-007, and 10TR2-003.

This inspector witnessed carbon arc gouging of traveler rail 22TR3-002 in accordance with B- WR- 11875 in preparation for weld repair.

Bay 2

This inspector witnessed weld repair of traveler rail 20TR1-014-005 per B- WR- 11805. The welder was identified as 045270. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Yang Qing Feng.

This inspector witnessed weld repair of traveler rail 20TR1-003-003 per B- WR- 11988. The welder was identified as 045209. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

Bay 1

This inspector witnessed welding of traveler rail 20TR2-033. The welder was identified as 216872. The welding procedure was identified as WPS-B-T-2231-Tc-U5-F. ZPMC QC was identified as Mr. Xiang Feng Feng.

Unless otherwise noted, all work performed on this day appeared to comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
